

Work Order ID 56652

Wednesday, March 03, 2010 1:02:04 PM



Page 1

Item ID: D3730-1

Revision ID:

Item Name: Angle

Start Date: 3/3/2010 Start Qty: 10.00

Required Date: 3/10/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: MW

Date: 10-3-3

QC:

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3730

Rev B

100



BAND SAW

Bandsaw

Jeaspa Bandsaw

Memo

Cut to Length as per Dwg D3730

0.00

110



CONVENTIONAL MILLING MACHINE

Mill Conv

Conventional Milling Machine

Memo

1- drill holes as per dwg D3730 2-Deburr

0.00

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

SL 10/03/06

(10)

SL 10/03/07

SL 10/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56652

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Item ID: D3730-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 3/3/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 3/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC8- Inspect parts - second check

0.00

S. P 10/03/04

10

0.00

140



Small Fab

Small Fab

0.00

0.00

1- Grind radius as per dwg D3730-2- Deburr if necessary

JL 10/03/07

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S. P 10/08

(10)

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Work Order ID 56652

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Item ID: D3730-1

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Item Name: Angle

Start Date: 3/3/2010 Start Qty: 10.00

Required Date: 3/10/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Setup Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center ID

160



HandFinish

Hand Finishing

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
Code

Qty

Accept
Qty

Qty

Reject
Qty

Number

Reject
Number

Stamp

0.00

ell 10/05/08

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location: Steven

0.00

WA

0.00

W/O:		WORK ORDER CHANGES					
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Work Order ID 56652

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Wednesday, March 03, 2010 1:02:04 PM

Item ID: D3730-1

Accept



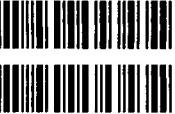
Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 3/3/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 3/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/03/11 AJ

Memo

0.00

MF
0.3-10

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Picklist Print

Wednesday, March 03, 2010 1:02:03 PM

Page 1

Work Order ID: 56652



Parent Item: D3730-1



Parent Item Name: Angle

Start Date: 3/3/2010

Required Date: 3/10/2010

Comments: IPP Rev:A 08-01-30 new issue DD verified by:
IPP Rev:B 08-03-19 chg to revB ecn 1158 DD verified by:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6A.750W.125			No			100	f	51.4700	1.7537			

angle .750 x .750 x .125w

Warehouse

Location

Main Warehouse

MAT	51.47
18147	51.47

Loc Qty

Loc Code

1.76 SL 10/03/07

D6201

1X1X.125 w

46909

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DART AEROSPACE LTD	Work Order:	56652
Description: Angle	Part Number:	D3730-1
Inspection Dwg: D3730	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	JL	Audited by:	SP	Prototype Approval:	N/A
Date:	10/03/06	Date:	10/03/08	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	08.04.17	New Issue		KJ/DD	DD

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

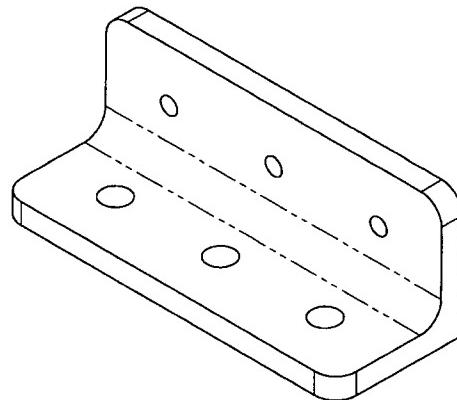
D

C

C

B

B



D3730-1 ANGLE △

96650

08-03-17 MF

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW125) △
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

8 7 6 5 4 3 2 1

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED. ISO VIEW UPDATED. SHEET 2 ZONE C4, Ø 0.098 HOLES WERE Ø 0.159, ZONE 7B 0.440 DIM WAS 0.450.	AJS	08.03.06
A	NEW ISSUE	AJS	08.01.31
REV.	DESCRIPTION		
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	DA	D3730	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MF	ANGLE	NTS
DATE	08.03.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

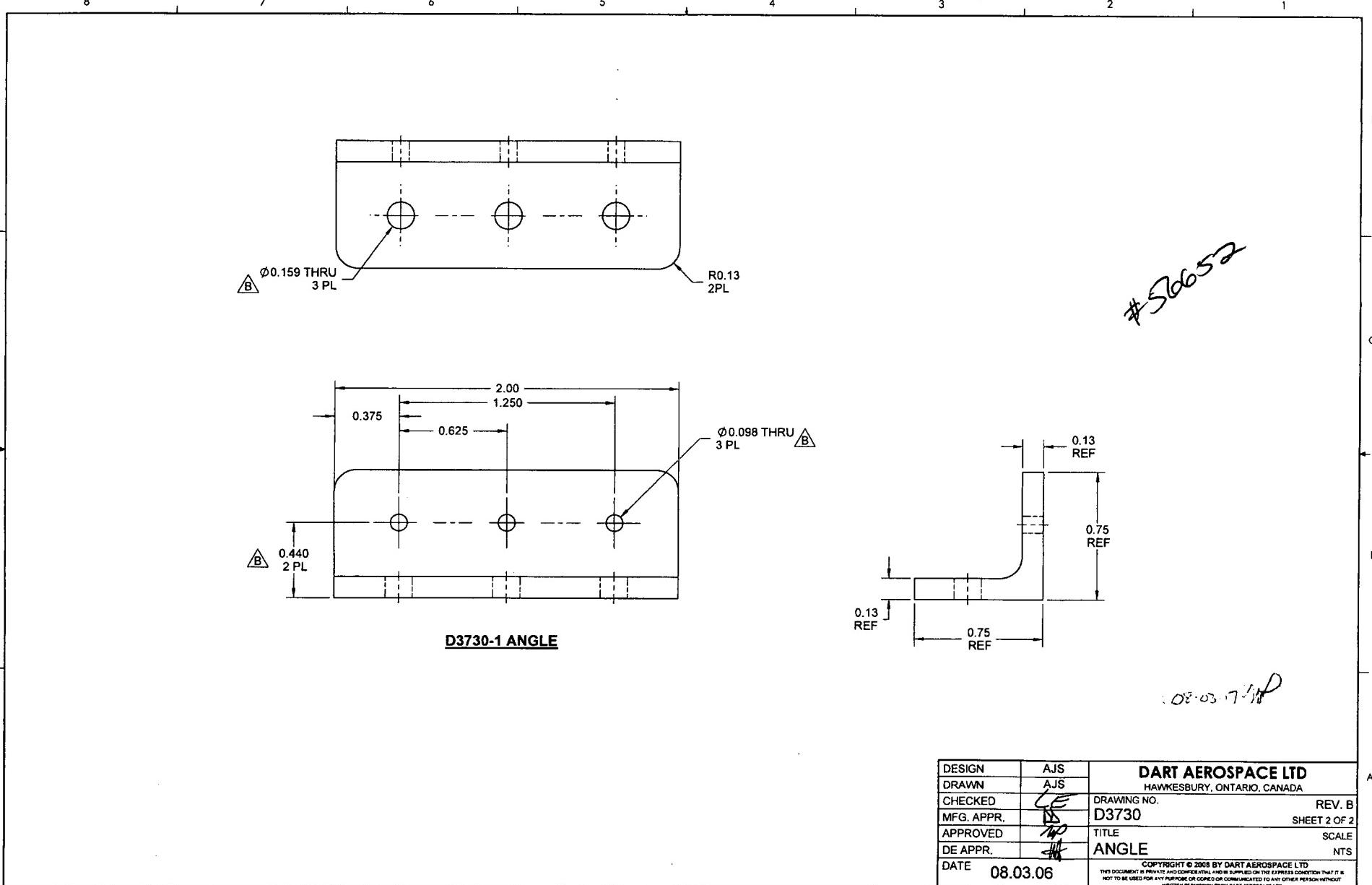
A

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